

1           81. A method for producing a polymeric foamed material panel  
2 comprising:  
3           cutting a polymeric foamed material with a hot wire cutter in a first direction  
4 from a surface of the polymeric foamed material wherein the first direction is generally  
5 perpendicular to the surface;  
6           cutting subsequently with the hot wire cutter the polymeric foamed material in  
7 a second direction generally perpendicular to the first direction to produce a first cut seared  
8 surface terminating in opposed ends of said polymeric foamed material;  
9           cutting subsequently with the hot wire cutter the polymeric foamed material in  
10 a third direction generally perpendicular to the second direction to produce a second cut  
11 seared surface terminating in said opposed ends of said polymeric foamed material;  
12           providing a brace member having a web and at least one flange secured to the  
13 web; and  
14           disposing respectively the web and the flange of the brace member against the  
15 first cut seared surface and the second cut seared surface to produce a polymeric foamed  
16 material panel.

1           82. The method of Claim 81 additionally comprising cutting with said hot  
2 wire cutter said polymeric foamed material to produce a defined planar surface; and said  
3 surface is a defined side surface of the polymeric foamed material.

1           83. The method of Claim 82 wherein said second direction is a generally  
2 perpendicular direction from said defined planar surface.

1           84. The method of Claim 81 additionally comprising forming a flange-  
2 return slot in said polymeric foamed material; and said providing a brace member comprises  
3 providing said brace member to additionally have a flange return secured to said flange.

1           85. The method of Claim 83 additionally comprising forming a flange-  
2 return slot in said polymeric foamed material; and said providing a brace member comprises  
3 providing said brace member to additionally have a flange return secured to said flange.

1           86. The method of Claim 84 additionally comprising disposing said flange  
2 return of said brace member in said flange-return slot in said polymeric foamed material.

1           87. The method of Claim 85 additionally comprising disposing said flange  
2 return of said brace member in said flange-return slot in said polymeric foamed material.

1           88. The method of Claim 81 additionally comprising cutting with the hot  
2 wire cutter the polymeric foamed material to produce a third cut seared surface terminating in  
3 said opposed ends of said polymeric foamed material; and cutting with the hot wire cutter the  
4 polymeric foamed material to produce a fourth cut seared surface terminating in said opposed  
5 ends of said polymeric foamed material.

b38  
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1           89. The method of Claim 86 additionally comprising cutting with the hot  
2 wire cutter the polymeric foamed material to produce a third cut seared surface terminating in  
3 said opposed ends of said polymeric foamed material; and cutting with the hot wire cutter the  
4 polymeric foamed material to produce a fourth cut seared surface terminating in said opposed  
5 ends of said polymeric foamed material.

1           90. The method of Claim 88 additionally comprising providing a second  
2 brace member having a second web and at least one second flange secured to the second  
3 web; and disposing respectively the second web and the second flange of the second brace  
4 member against the fourth cut seared surface and the third cut seared surface.

1           91. The method of Claim 89 additionally comprising providing a second  
2 brace member having a second web and at least one second flange secured to the second  
3 web; and disposing respectively the second web and the second flange of the second brace  
4 member against the fourth cut seared surface and the third cut seared surface.

1           92. The method of Claim 88 wherein said fourth cut seared surface is  
2 generally perpendicular to said third cut seared surface.

1           93. The method of Claim 91 wherein said fourth cut seared surface is  
2 generally perpendicular to said third cut seared surface.

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1           94. The method of Claim 90 additionally comprising forming a second  
2 flange-return slot in said polymeric foamed material; and said providing a second brace  
3 member comprises providing said second brace member to additionally have a second flange  
4 return secured to said second flange.

1           95. The method of Claim 91 additionally comprising forming a second  
2 flange-return slot in said polymeric foamed material; and said providing a second brace  
3 member comprises providing said second brace member to additionally have a second flange  
4 return secured to said second flange.

1           96. The method of Claim 94 additionally comprising disposing said  
2 second flange return of said second brace member in said second flange-return slot in said  
3 polymeric foamed material.

1           97. The method of Claim 95 additionally comprising disposing said  
2 second flange return of said second brace member in said second flange-return slot in said  
3 polymeric foamed material.

1           98. The method of Claim 82 wherein said brace member having a web and  
2 at least one flange secured to the web comprises said brace member having said web, a first  
3 flange secured to said web, and a second flange secured to said web; and said disposing  
4 additionally comprises respectively positioning the web and the first flange of the brace  
5 member against the first cut seared surface and the second cut seared surface such that said  
6 second flange is generally aligned with the defined planar surface of the polymeric foamed  
7 material.

1           99. The method of Claim 98 additionally comprising forming a first  
2 flange-return slot in the polymeric foamed material and forming a second flange-return slot  
3 in the polymeric foamed material; said brace member additionally comprises a first flange  
4 return secured to said first flange and a second flange return secured to said second flange;  
5 and said disposing additionally comprises respectively positioning said first flange return and

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1           104. The method of Claim 91 wherein a portion of the web of the brace  
2 member and a portion of the second web of the second brace member protrude from the  
3 polymeric foamed material panel.

1           105. The method of Claim 103 additionally comprising securing a track  
2 member to the brace member.

1           106. The method of Claim 104 additionally comprising securing a track  
2 member to the brace member and to the second brace member.

1           107. The method of Claim 81 additionally comprising cutting the polymeric  
2 foamed material with the hot wire cutter to produce the polymeric foamed material having a  
3 tongue and a channel.

1           108. The method of Claim 98 additionally comprising cutting the polymeric  
2 foamed material with the hot wire cutter to produce the polymeric foamed material having a  
3 tongue and a channel; and said cutting subsequently with the hot wire cutter the polymeric  
4 foamed material in said second direction additionally producing an opposed first cut seared  
5 surface terminating in said opposed ends of said polymeric foamed material and opposed to  
6 said first cut seared surface such that said opposed first cut seared surface and said first cut  
7 seared surface form a first slot wherein said web of said brace member lodges; and said  
8 cutting subsequently with the hot wire cutter the polymeric foamed material in said third  
9 direction additionally producing an opposed second cut seared surface terminating in said  
10 opposed ends of said polymeric foamed material and opposed to said second cut seared  
11 surface such that said opposed second cut seared surface and said second cut seared surface  
12 form a second slot wherein said flange of said brace member lodges.

1           109. The method of Claim 102 additionally comprising cutting the  
2 polymeric foamed material with the hot wire cutter to produce the polymeric foamed material  
3 having a tongue and a channel.

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1           110. The method of Claim 81 additionally comprising computer operating  
2        said hot wire cutter; and said polymeric foamed material is generally stationary.

1           111. The method of Claim 98 additionally comprising computer operating  
2        said hot wire cutter; and said polymeric foamed material is generally stationary.

1           112. The method of Claim 109 additionally comprising computer operating  
2        said hot wire cutter; and said polymeric foamed material is generally stationary.

1           113. A polymeric foamed material panel produced in accordance with the  
2        method of Claim 81.

1           114. A polymeric foamed material panel produced in accordance with the  
2        method of Claim 90.

1           115. A polymeric foamed material panel produced in accordance with the  
2        method of Claim 99.

1           116. A polymeric foamed material panel produced in accordance with the  
2        method of Claim 102.

1           117. A polymeric foamed material panel produced in accordance with the  
2        method of Claim 103.

1           118. A polymeric foamed material panel produced in accordance with the  
2        method of Claim 104.

1           119. A polymeric foamed material panel produced in accordance with the  
2        method of Claim 112.

1           120. A method for producing a plurality of polymeric foamed material  
2        structures having seared surfaces for contacting brace members comprising the steps of:

- 3           a) providing a block of polymeric foamed material having a side and a pair of  
4        opposed ends;

- 5        b) cutting the block of polymeric foamed material with a plurality of hot wire  
6        cutters in a first direction generally perpendicular from said side of said block  
7        of polymeric foamed material;  
8        c) cutting, immediately after said cutting step (b), the block of polymeric  
9        foamed material with the plurality of hot wire cutters in a second direction  
10      generally perpendicular from said first direction until each hot wire cutter  
11      forms in the polymeric foamed material a first respective cut seared surface  
12      terminating in said opposed ends of said block of polymeric foamed material;  
13      d) cutting, immediately after said cutting step (c), the block of polymeric  
14      foamed material with the plurality of hot wire cutters in a third direction  
15      generally perpendicular from said second direction until each hot wire cutter  
16      forms in the polymeric foamed material a second respective cut seared  
17      surface terminating in said opposed ends of said block of said polymeric  
18      foamed material;  
19      e) cutting the block of polymeric foamed material with the plurality of hot wire  
20      cutters in a fourth direction until each hot wire cutter forms in the polymeric  
21      foamed material a third respective cut seared surface terminating in said  
22      opposed ends of said block of polymeric foamed material;  
23      f) cutting the block of polymeric foamed material with the plurality of hot wire  
24      cutters in a fifth direction until each hot wire cutter forms in the polymeric  
25      foamed material a fourth respective cut seared surface terminating in said  
26      opposed ends of said block of polymeric foamed material; and  
27      g) cutting the block of polymeric foamed material with the plurality of hot wire  
28      cutters in a sixth direction to produce a plurality of polymeric foamed  
29      material structures, each of said polymeric foamed material structures having  
30      a first cut seared surface and a second cut seared surface for contacting a first  
31      brace member and a third cut seared surface and a fourth cut seared surface  
32      for contacting a second brace member.

1        121. <sup>1</sup> The method of Claim ~~120~~ additionally comprising cutting the block of  
2        polymeric foamed material with the plurality of hot wire cutters between said cutting step (d)  
3        and said cutting step (e).

1        122. <sup>1</sup> The method of Claim ~~120~~ additionally comprising cutting the block of  
2        polymeric foamed material with the plurality of hot wire cutters such that each of said  
3        polymeric foamed material structures has a tongue member and a channel member.

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*Am*      123. <sup>3</sup> ~~1~~ The method of Claim ~~121~~ additionally comprising cutting the block of  
2        polymeric foamed material with the plurality of hot wire cutters such that each of said  
3        polymeric foamed material structures has a tongue member and a channel member.

1        124. <sup>1</sup> The method of Claim ~~120~~ wherein said cutting step (f) is before said  
2        cutting step (e).

1        125. <sup>3</sup> ~~1~~ The method of Claim ~~123~~ wherein said cutting step (g) is after said  
2        cutting step (f).

1        126. <sup>5</sup> ~~1~~ The method of Claim ~~121~~ additionally comprising computer operating  
2        said hot wire cutters; and said block of polymeric foamed material is generally stationary;  
3        and said cutting step (c) additionally producing an opposed first respective cut seared surface  
4        terminating in said opposed ends of said block of polymeric foamed material and opposed to  
5        said first respective cut seared surface to form a first slot in each of said polymeric foamed  
6        material structures; and said cutting step (d) additionally producing an opposed second  
7        respective cut seared surface terminating in said opposed ends of said block of polymeric  
8        foamed material and opposed to said second respective cut seared surface to form a second  
9        slot in each of said polymeric foamed material structures, each of said polymeric foamed  
10      material structures having said first slot and said second slot for receiving a first brace  
11      member; and said cutting step (e) additionally producing an opposed third respective cut  
12      seared surface terminating in said opposed ends of said block of polymeric foamed material  
13      and opposed to said third respective cut seared surface to form a third slot in each of said  
14      polymeric foamed material structures; and said cutting step (f) additionally producing an

15 opposed fourth respective cut seared surface terminating in said opposed ends of said block  
16 of polymeric foamed material and opposed to said fourth respective cut seared surface to  
17 form a fourth slot in each of said polymeric foamed material structures, each of said  
18 polymeric foamed material structures having said third slot and said fourth slot for receiving  
19 a second brace member.

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1                         8                         7  
2     127. The method of Claim 124 additionally comprising computer operating  
3     said hot wire cutters; and said block of polymeric foamed material is generally stationary;  
4     and said fifth direction is generally perpendicular from said fourth direction; and said sixth  
direction is generally perpendicular from said fifth direction.

*C*                         1                         1  
2     128. The method of Claim 120 additionally comprising forming a first  
3     return slot, a second flange-return slot, a third flange-return slot, and a fourth flange-return  
slot in each of the polymeric foamed material structures.

*C*                         1                         7                         first flange  
2     129. The method of Claim 124 additionally comprising forming a first  
3     return slot, a second flange-return slot, a third flange-return slot, and a fourth flange-return  
slot in each of the polymeric foamed material structures.

*C*                         1                         12  
2     130. The method of Claim 128 additionally comprising providing a  
3     plurality of first brace members wherein each of said first brace members comprises a first  
4     web, a first flange secured to said first web, a first flange return secured to said first flange, a  
5     second flange secured to said web, and a second flange return secured to said second flange;  
6     and additionally comprising providing a plurality of second brace members wherein each of  
7     said second brace members comprises a second web, a third flange secured to said second  
8     web, a third flange return secured to said third flange, a fourth flange secured to said second  
9     web, a fourth flange return secured to said fourth flange; and disposing the plurality of the  
10    first brace members and the plurality of the second brace members in the plurality of  
11    polymeric foamed material structures such that each of said polymeric foamed material  
12    structures comprises the first web of the first brace member positioned against the first cut  
seared surface, the first flange positioned against the second cut secured surface, the first  
13    flange return positioned in the first flange-return slot, the second flange return positioned in

14 the second flange-return slot, the second web of the second brace member positioned against  
15 the fourth cut seared surface, the third flange positioned against the third cut seared surface,  
16 the third flange return positioned in the third flange-return slot, and the fourth flange return  
17 positioned in the fourth flange-return slot.

1                          131. The method of Claim 129 additionally comprising providing a  
2 plurality of first brace members wherein each of said first brace members comprises a first  
3 web, a first flange secured to said first web, a first flange return secured to said first flange, a  
4 second flange secured to said web, and a second flange return secured to said second flange;  
5 and additionally comprising providing a plurality of second brace members wherein each of  
6 said second brace members comprises a second web, a third flange secured to said second  
7 web, a third flange return secured to said third flange, a fourth flange secured to said second  
8 web, a fourth flange return secured to said fourth flange; and disposing the plurality of the  
9 first brace members and the plurality of the second brace members in the plurality of  
10 polymeric foamed material structures such that each of said polymeric foamed material  
11 structures comprises the first web of the first brace member positioned against the first cut  
12 seared surface, the first flange positioned against the second cut secured surface, the first  
13 flange return positioned in the first flange-return slot, the second flange return positioned in  
14 the second flange-return slot, the second web of the second brace member positioned against  
15 the fourth cut seared surface, the third flange positioned against the third cut seared surface,  
16 the third flange return positioned in the third flange-return slot, and the fourth flange return  
17 positioned in the fourth flange-return slot.

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gmt*

1                          132. The method of Claim 130 additionally comprising cutting the block of  
2 polymeric foamed material prior to said cutting step (g).

1                          133. The method of Claim 130 additionally comprising cutting the block of  
2 polymeric foamed material after said cutting step (g) and prior to disposing the plurality of  
3 the first brace members and the plurality of the second brace members in the plurality of  
4 polymeric foamed material structures.

1                   17  
2 134. A plurality of polymeric foamed material structures produced in  
accordance with the method of Claim 120.

1                   18  
2 135. A plurality of polymeric foamed material structures produced in  
accordance with the method of Claim 130.

1                   19  
2 136. A plurality of polymeric foamed material structures produced in  
accordance with the method of Claim 131.

1                   20  
2 137. A method for producing a polymeric foamed material panel  
comprising the steps of:  
3                   21  
4                 a) obtaining a polymeric foamed material structure produced in  
accordance with a method comprising:

5                   22  
6                 cutting a polymeric foamed material with a cutter in a first direction  
from a side of the polymeric foamed material wherein the first direction is generally  
7                   23  
8                 perpendicular to the side and said cutter is selected from the group consisting of a hot wire  
cutter and a laser cutter;

9                   24  
10                cutting subsequently with the cutter the polymeric foamed material in  
a second direction from the first direction to produce a first cut surface terminating in  
11                25  
12                opposed ends of said polymeric foamed material;

13                26  
14                cutting subsequently with the cutter the polymeric foamed material in  
a third direction from the second direction to produce a second cut surface terminating in said  
15                27  
16                opposed ends of said polymeric foamed material; and

17                28  
18                b) providing a brace member having a web and at least one flange  
secured to the web; and

19                29  
20                c) disposing the brace member in the polymeric foamed material  
structure such that the web is against the first cut surface and the flange is against the second  
cut surface to produce a polymeric foamed material panel.

1                   30  
2 138. The method of Claim 137 wherein said second direction is generally  
perpendicular from the first direction.

1           139. The method of Claim 137 wherein said third direction is generally  
2 perpendicular from the second direction.

1           140. The method of Claim 138 wherein said third direction is generally  
2 perpendicular from the second direction.

1           141. The method of Claim 137 wherein said method in obtaining step (a)  
2 for producing said polymeric foamed material structure additionally comprises cutting the  
3 polymeric foamed material with the cutter to produce the polymeric foamed material having  
4 a tongue and a channel.

B38  
cont

1           142. The method of Claim 140 wherein said method in obtaining step (a)  
2 for producing said polymeric foamed material structure additionally comprises cutting the  
3 polymeric foamed material with the cutter to produce the polymeric foamed material having  
4 a tongue and a channel.

1           143. The method of Claim 137 wherein said brace member comprises a  
2 generally C-shape.

1           144. The method of Claim 140 wherein said brace member comprises a  
2 generally C-shape.

1           145. The method of Claim 141 wherein said brace member comprises a  
2 generally C-shape.

1           146. The method of Claim 137 wherein said brace member comprises a  
2 generally Z-shape.

1           147. The method of Claim 141 wherein said brace member comprises a  
2 generally Z-shape.

1           148. The method of Claim 57 wherein a portion of the web of the brace  
2 member protrudes from the polymeric foamed material panel.

1           149. The method of Claim 140 wherein a portion of the web of the brace  
2 member protrudes from the polymeric foamed material panel.

1           150. The method of Claim 146 wherein a portion of the web of the brace  
2 member protrudes from the polymeric foamed material panel.

1           151. The method of Claim 137 wherein said method in obtaining step (a)  
2 for producing said polymeric foamed material structure additionally comprising forming,  
3 prior to said disposing step (c), a flange-return slot in the polymeric foamed material; and  
4 said providing a brace member comprises providing said brace member to additionally have  
5 a flange return secured to said flange.

B38  
cont

1           152. The method of Claim 141 wherein said method in obtaining step (a)  
2 for producing said polymeric foamed material structure additionally comprising forming,  
3 prior to said disposing step (c), a flange-return slot in the polymeric foamed material; and  
4 said providing a brace member comprises providing said brace member to additionally have  
5 a flange return secured to said flange

1           153. The method of Claim 151 additionally comprising disposing said  
2 flange return of said brace member in said flange-return slot in said polymeric foamed  
3 material structure.

1           154. The method of Claim 152 additionally comprising disposing said  
2 flange return of said brace member in said flange-return slot in said polymeric foamed  
3 material structure.

1           155. The method of Claim 137 wherein said method in said obtaining step  
2 (a) for producing said polymeric foamed material structure additionally comprising cutting  
3 with the cutter the polymeric foamed material to produce a third cut surface terminating in  
4 said opposed ends of said polymeric foamed material; and cutting with the cutter the  
5 polymeric foamed material to produce a fourth cut surface terminating in said opposed ends  
6 of said polymeric foamed material.

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1           156. The method of Claim 141 wherein said method in said obtaining step  
2 (a) for producing said polymeric foamed material structure additionally comprising cutting  
3 with the cutter the polymeric foamed material to produce a third cut surface terminating in  
4 said opposed ends of said polymeric foamed material; and cutting with the cutter the  
5 polymeric foamed material to produce a fourth cut surface terminating in said opposed ends  
6 of said polymeric foamed material.

B35  
cont  
1           157. The method of Claim 155 additionally comprising providing a second  
2 brace member having a second web and at least one second flange secured to the second  
3 web; and disposing respectively the second web and the second flange of the second brace  
4 member against the fourth cut surface and the third cut surface.

1           158. The method of Claim 156 additionally comprising providing a second  
2 brace member having a second web and at least one second flange secured to the second  
3 web; and disposing respectively the second web and the second flange of the second brace  
4 member against the fourth cut surface and the third cut surface.

1           159. The method of Claim 137 wherein said method in obtaining step (a)  
2 for producing said polymeric foamed material structure additionally comprising computer  
3 operating said cutter; and said polymeric foamed material is generally stationary; and said  
4 side is a defined surface of the polymeric foamed material.

1           160. A method for producing a polymeric foamed material panel  
2 comprising the steps of:

3           a) providing a polymeric foamed material structure comprising a  
4 pair of opposed ends, a side surface, a first hotwire-cut seared surface having been cut by a  
5 hotwire cutter in a first direction relative to said side surface and terminating in said pair of  
6 opposed ends, a second hotwire-cut seared surface having been cut by a hotwire cutter in a  
7 second direction from said first hotwire-cut seared surface and terminating in said pair of  
8 opposed ends, and a third hotwire-cut seared surface having been cut by a hotwire cutter in a

9 third direction from said second hotwire-cut seared surface and terminating in said pair of  
10 opposed ends;

11                   b) providing a brace member having a web and at least one flange  
12 secured to the web; and  
13                   c) disposing respectively the web and the flange of the brace  
14 member against the second hotwire-cut seared surface and the third hotwire-cut seared  
15 surface to produce a polymeric foamed material panel.

1                   161. <sup>19</sup> The method of Claim <sup>160</sup> wherein said first direction is generally  
2 perpendicular to said side surface.

1                   162. <sup>20</sup> <sup>18</sup> The method of Claim <sup>160</sup> wherein said brace member comprises a  
2 generally C-shape.

1                   163. <sup>22</sup> <sup>18</sup> The method of Claim <sup>160</sup> wherein said brace member comprises a  
2 generally Z-shape.

1                   164. <sup>21</sup> <sup>20</sup> The method of Claim <sup>162</sup> wherein a portion of the web of the brace  
2 member protrudes from the polymeric foamed material panel.

1                   165. <sup>23</sup> A polymeric foamed material panel produced in accordance with the  
2 method of Claim <sup>160</sup>. <sup>18</sup>

1                   166. <sup>24</sup> A method for forming a structure comprising the steps of:  
2                   a) cutting a first polymeric foamed material with a first cutter in a  
3 first direction relative to a first side surface of the first polymeric foamed material;  
4                   b) cutting with the first cutter the first polymeric foamed material  
5 in a second direction relative to the first direction to produce a first-cutter first cut surface  
6 terminating in opposed ends of said first polymeric foamed material;  
7                   c) cutting with the first cutter the first polymeric foamed material  
8 in a third direction relative to the second direction to produce a first-cutter second cut surface  
9 terminating in said opposed ends of said first polymeric foamed material;

- 10                   d) cutting the first polymeric foamed material with the first cutter  
11 to produce a first tongue in the first polymeric foamed material;  
12                   e) providing a first brace member having a first web and at least  
13 one first flange secured to the first web;  
14                   f) disposing respectively the first web and the first flange of the  
15 first brace member against the first-cutter first cut surface of step (b) and the first-cutter  
16 second cut surface of step (c) to produce a first polymeric foamed material panel having said  
17 first tongue;
- 18                   g) cutting a second polymeric foamed material with a second  
19 cutter to produce a second channel in the second polymeric foamed material;  
20                   h) cutting the second polymeric foamed material with the second  
21 cutter in a first direction relative to a second side surface of the second polymeric foamed  
22 material;  
23                   i) cutting with the second cutter the second polymeric foamed  
24 material in a second direction relative to the first direction to produce a second-cutter first cut  
25 surface terminating in opposed ends of said second polymeric foamed material;  
26                   j) cutting with the second cutter the second polymeric foamed  
27 material in a third direction relative to the second direction to produce a second-cutter second  
28 cut surface terminating in said opposed ends of said second polymeric foamed material;  
29                   k) providing a second brace member having a second web and at  
30 least one second flange secured to the second web;  
31                   l) disposing respectively the second web and the second flange of  
32 the second brace member against the second-cutter first cut surface of step (i) and the  
33 second-cutter second cut surface of step (j) to produce a second polymeric foamed material  
34 panel having said second channel; and  
35                   m) sliding said first tongue of said first polymeric foamed material  
36 panel into said second channel of said second polymeric foamed material panel to form a  
37 structure.

1                   25                   26  
167. The method of Claim 166 additionally comprising cutting the first  
2 polymeric foamed material with the first cutter to produce a first channel in the polymeric

3 foamed material and cutting the second polymeric foamed material with the second cutter to  
4 produce a second tongue in the second polymeric foamed material.

1       <sup>27</sup> 168. The method of Claim <sup>24</sup> 166 wherein said first direction of step (a) is  
2 generally perpendicular to the first side surface of step (a); said second direction of step (b) is  
3 generally perpendicular to said first direction of step (a); said third direction step (c) is  
4 generally perpendicular to said second direction of step (b); and wherein said first direction  
5 of step (h) is generally perpendicular to the second side surface of step (h); said second  
6 direction of step (i) is generally perpendicular to said first direction of step (h); said third  
7 direction of step (j) is generally perpendicular to said second direction of step (i).

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1       <sup>24</sup> 169. The method of Claim <sup>25</sup> 167 wherein said first direction of step (a) is  
2 generally perpendicular to the first side surface of step (a); said second direction of step (b) is  
3 generally perpendicular to said first direction of step (a); said third direction step (c) is  
4 generally perpendicular to said second direction of step (b); and wherein said first direction  
5 of step (h) is generally perpendicular to the second side surface of step (h); said second  
6 direction of step (i) is generally perpendicular to said first direction of step (h); said third  
7 direction of step (j) is generally perpendicular to said second direction of step (i).

1       <sup>28</sup> 170. The method of Claim <sup>24</sup> 166 additionally comprising cutting respectively  
2 said first polymeric foamed material with said first cutter in said cutting steps (a) through (d)  
3 generally simultaneously with cutting respectively said second polymeric foamed material  
4 with said second cutter in said cutting steps (g) through (j).

1       <sup>29</sup> 171. The method of Claim <sup>24</sup> 166 wherein said cutting step (b) additionally  
2 producing an opposed first-cutter first cut surface terminating in said opposed ends of said  
3 first polymeric foamed material and opposed to said first-cutter first cut surface to form a  
4 first-cutter first slot in said first polymeric foamed material; and said cutting step (c)  
5 additionally producing an opposed first-cutter second cut surface terminating in said opposed  
6 ends of said first polymeric foamed material and opposed to said first-cutter second cut  
7 surface to form a first-cutter second slot in said first polymeric foamed material such that  
8 after said disposing step (f) said first web and said first flange of said first brace member are

9 further disposed respectively in said first-cutter first slot and in said first-cutter second slot;  
10 and said cutting step (i) additionally producing an opposed second-cutter first cut surface  
11 terminating in said opposed ends of said second polymeric foamed material and opposed to  
12 said second-cutter first cut surface to form a second-cutter first slot in said second polymeric  
13 foamed material; and said cutting step (j) additionally producing an opposed second-cutter  
14 second cut surface terminating in said opposed ends of said second polymeric foamed  
15 material and opposed to said second-cutter second cut surface to form a second-cutter second  
16 slot in said second polymeric foamed material such that after said disposing step (l) said  
17 second web and said second flange of said second brace member are further disposed  
18 respectively in said second-cutter first slot and in second-cutter second slot.

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30  
1 172. The method of Claim 166 wherein said second cutter and said first  
2 cutter are respectively a cutter selected from the group consisting of a hotwire cutter and a  
3 laser cutter.

31  
1 173. The method of Claim 166 wherein said first brace member comprises a  
2 generally C-shape, and a portion of the first web of the first brace member protrudes from the  
3 first polymeric foamed material panel.

32  
1 174. A structure produced in accordance with the method of Claim 166.

33  
1 175. A method for forming a structure comprising the steps of:  
2       a) providing a first polymeric foamed material structure  
3 comprising a pair of opposed first ends, a first defined side surface, a first tongue, a first  
4 hotwire-cut seared surface having been cut by a hotwire cutter in a first direction relative to  
5 said first defined side surface and terminating in said pair of opposed first ends, a second  
6 hotwire-cut seared surface having been cut by a hotwire cutter in a second direction from  
7 said first hotwire-cut seared surface and terminating in said pair of opposed first ends, and a  
8 third hotwire-cut seared surface having been cut by a hotwire cutter in a third direction from  
9 said second hotwire-cut seared surface and terminating in said pair of opposed first ends;  
10       b) providing a first brace member having a first web and at least  
11 one first flange secured to the web;

12                   c)     disposing respectively the first web and the first flange of the  
13     first brace member against the second hotwire-cut seared surface of step (a) and the third  
14     hotwire-cut seared surface of step (a) to produce a first polymeric foamed material panel  
15     having said first tongue;

16                   d)     providing a second polymeric foamed material structure  
17     comprising a pair of opposed second ends, a second defined side surface, a second channel, a  
18     first hotwire-cut seared surface having been cut by a hotwire cutter in a first direction relative  
19     to said second defined side surface and terminating in said pair of opposed second ends, a  
20     second hotwire-cut seared surface having been cut by a hotwire cutter in a second direction  
21     from said first hotwire-cut seared surface and terminating in said pair of opposed second  
22     ends, and a third hotwire-cut seared surface having been cut by a hotwire cutter ~~and~~ in a third  
23     direction from said second hotwire-cut seared surface and terminating in said pair of opposed  
24     second ends;

25                   e)     providing a second brace member having a second web and at  
26     least one second flange secured to the web;

27                   f)     disposing respectively the second web and the second flange of  
28     the second brace member against the second hotwire-cut seared surface of step (d) and the  
29     third hotwire-cut seared surface of step (d) to produce a second polymeric foamed material  
30     panel having said second channel; and

31                   g)     disposing said first tongue of said first polymeric foamed  
32     material panel into said second channel of said second polymeric foamed material panel to  
33     form a structure.

1                   35     176. A structure formed in accordance with the method of Claim 175.

1                   35     177. A method for producing a plurality of polymeric foamed material  
2     panels comprising the steps of:

3                   a)     cutting a polymeric foamed material with a plurality of cutters  
4     in a generally perpendicular direction from a defined surface of the polymeric foamed  
5     material;

6                   b) cutting in at least a second direction the polymeric foamed  
7 material of step (a) with the plurality of cutters until each cutter forms in the polymeric  
8 foamed material a first respective slot terminating in opposed ends of the polymeric foamed  
9 material;

10                  c) cutting with the plurality of cutters the polymeric foamed  
11 material of step (b) in said generally perpendicular direction of step (a) to produce a plurality  
12 of polymeric foamed material structures having first slots; and

13                  d) disposing first brace members in the first slots of the polymeric  
14 foamed material structures of step (c) to produce a plurality of polymeric foamed material  
15 panels with each polymeric foamed material panel having one of said first brace members.

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Omt  
1                 178. The method of Claim 177 wherein said first brace members each  
2 comprise a generally C-shape, and said defined surface is a side of said polymeric foamed  
3 material.

1                 179. The method of Claim 178 wherein each of first brace members include  
2 a web a portion which protrudes from said polymeric foamed material panel.

1                 180. A plurality of polymeric foamed material panels produced in  
2 accordance with the method of Claim 177.

1                 181. The method of Claim 177 additionally comprising cutting the  
2 polymeric foamed material with the plurality of cutters until each cutter forms a second  
3 respective slot in the polymeric foamed material and said produced plurality of polymeric  
4 foamed material structures include second slots.

1                 182. The method of Claim 181 additionally comprising disposing second  
2 brace members in the second slots of the produced polymeric foamed material structures  
3 such that each polymeric foamed material panel includes one of said second brace members.

1                 183. A method for producing a plurality of polymeric foamed material  
2 panels comprising the steps of:

3                   a) providing a block of polymeric foamed material in a generally  
4 stationary position having a defined surface and a pair of opposed ends;

5                   b) moving from said defined surface a plurality of cutters through  
6 the generally stationary block of polymeric foamed material of step (a) in a generally  
7 perpendicular direction of travel;

8                   c) interrupting the movement of the plurality of cutters from said  
9 generally perpendicular direction of travel through the generally stationary blocks of  
10 polymeric foamed material to move the cutters in at least one direction of travel which differs  
11 from said generally perpendicular direction of travel such that each cutter produces a  
12 respective brace-receiving slot in the polymeric foamed material terminating in said opposed  
13 ends;

14                  d) continuing said moving step (b) of said plurality of cutters in  
15 said generally perpendicular direction of travel, while intermittently interrupting the  
16 movement of the plurality of cutters from generally perpendicular direction of travel to move  
17 the cutters in at least one direction of travel which differs from said generally perpendicular  
18 direction of travel such that each cutter produces at least one additional respective brace-  
19 receiving slot in the polymeric foamed material, until said plurality of cutters have moved  
20 completely through the generally stationary block of polymeric foamed material after which  
21 a plurality of polymeric foamed material structures are produced with each polymeric foamed  
22 material structure having a plurality of brace-receiving slots; and

23                  e) disposing brace members into the brace-receiving slots of the  
24 polymeric foamed material structures of step (d) to produce a plurality of polymeric foamed  
25 material panels with each polymeric foamed material panel having two of said brace  
26 members.

1                  42  
184. A plurality of polymeric foamed material panels produced in  
2 accordance with the method of Claim 183.

1                  43  
185. The method of Claim 183 wherein said defined surface comprises a  
2 side of said block of polymeric foamed material.

1                  *186* A method for producing a plurality of polymeric foamed material  
2                  panels comprising the steps of:

- 3                  a) cutting a polymeric foamed material in a first direction with a  
4                  plurality of cutters generally moving in unison;
- 5                  b) cutting subsequently the polymeric foamed material of step (a)  
6                  in a second direction with said plurality of cutters generally moving in unison;
- 7                  c) cutting, after said cutting step (b), the polymeric foamed  
8                  material of step (b) in said first direction with said plurality of cutters generally moving in  
9                  unison;
- 10                 d) cutting, after said cutting step (c), the polymeric foamed  
11                 material of step (c) in a third direction with said plurality of cutters generally moving in  
12                 unison;
- 13                 e) cutting, after said cutting step (d), the polymeric foamed  
14                 material of step (d) in said first direction with said plurality of cutters generally moving in  
15                 unison until said cutters have cut through the polymeric foamed material of step (d) to  
16                 produce a plurality of polymeric foamed material structures having brace-receiving  
17                 configurations; and
- 18                 f) sliding brace members into the brace-receiving configurations  
19                 of said polymeric foamed material structures of step (e) to produce a plurality of polymeric  
20                 foamed material panels with each polymeric foamed material panel having one of said brace  
21                 members.

1                  *187* A plurality of polymeric foamed material panels produced in  
2                  accordance with the method of Claim *186*.

1                  *188* A method for producing a plurality of polymeric foamed material  
2                  panels comprising the steps of:

- 3                  a) providing a block of polymeric foamed material having a  
4                  defined surface and a pair of opposed ends;
- 5                  b) moving from said defined surface a plurality of cutters through  
6                  the block of polymeric foamed material in a generally perpendicular direction of travel, while

7 interrupting at least one time the moving of the plurality of cutters in said generally  
8 perpendicular direction of travel to move the cutters through the block of polymeric foamed  
9 material in at least one direction of travel which differs from said generally perpendicular  
10 direction of travel, such that each cutter produces a respective brace-receiving slot in the  
11 polymeric foamed material terminating in said opposed ends, until said plurality of cutters  
12 have moved completely through the block of polymeric foamed material to produce a  
13 plurality of polymeric foamed material structures with each structure having at least one  
14 brace-receiving slot; and

c) disposing a brace member into each brace-receiving slot of said polymeric foamed material structures to produce a plurality of polymeric foamed material panels with each of said polymeric foamed material panels having at least one brace member.

*47*      *44*  
189. The method of Claim 188 wherein said defined surface is a side  
surface of said block of polymeric foamed material.

190. A plurality of polymeric foamed material panels produced in accordance with the method of Claim 188.

191. A method for producing a polymeric foamed material panel comprising the steps of:

- a) providing a block of polymeric foamed material having a defined surface and a pair of opposed ends;
- b) cutting the block of polymeric foamed material in a first direction relative to the defined surface;
- c) cutting the block of polymeric foamed material in a second direction to produce a first slot including a first cut surface terminating in said opposed ends;
- d) cutting the block of polymeric foamed material from said first slot to produce a second slot communicating with the first slot and including a second cut surface terminating in said opposed ends; and

- e) disposing a brace member against said first cut surface and said second cut surface respectively in said first slot and in said second slot to produce a polymeric foamed material panel.

192. A polymeric foamed material panel produced in accordance with the method of Claim 191.

193. A method for producing a polymeric foamed material panel comprising the steps of:

- a) providing a polymeric foamed material having a pair of opposed ends;
  - b) cutting the block of polymeric foamed material in a first direction to produce a defined planar surface;
  - c) cutting the block of polymeric foamed material from said defined planar surface in a second direction relative to said first direction to produce a web-receiving slot including a web-contacting cut surface terminating in said opposed ends;
  - d) cutting the block of polymeric foamed material in at least one third direction from said web-receiving slot to produce a flange-receiving slot including a flange-contacting cut surface terminating in said opposed ends;
  - e) providing a brace member having a web, and a first flange and a second flange integrally secured to the web; and
  - f) disposing respectively said web and said first flange of said brace member against said web-contacting cut surface in said web-receiving slot and against said flange-contacting cut surface in said flange-receiving slot to produce a polymeric material panel having said second flange of said brace member generally aligned with said defined planar surface.

194. A polymeric foamed material panel produced in accordance with the method of Claim 193.

195. A method for producing a polymeric foamed material structure comprising the steps of:

- 3           a) providing a block of polymeric foamed material having a pair of opposed  
4           ends;  
5           b) cutting the block of polymeric foamed material in a first direction;  
6           c) cutting the block of polymeric foamed material in a second direction to  
7           produce a first cut surface terminating in said opposed ends;  
8           d) cutting the block of polymeric foamed material from said first cut surface to  
9           produce a second cut surface terminating in said opposed ends;  
10          e) providing a brace member having a web, a first flange secured to the web, and  
11           a second flange secured to the web; and  
12          f) disposing the web and the first flange of the brace member respectively  
13           against the first cut surface and the second cut surface to produce a polymeric  
14           foamed material structure.

1           196. The method of Claim 195 wherein said first cut surface and said  
2           second cut surface respectively comprise a first cut seared surface and a second cut seared  
3           surface produced by a hotwire cutter.

1           197. The method of Claim 195 wherein said providing step (a) additionally  
2           comprises providing the block of polymeric foamed material to have a defined surface, and  
3           cutting in said cutting step (b) is in said first direction which is generally perpendicular to  
4           said defined surface and produces a defined planar surface; and said disposing step (f)  
5           additionally comprises generally aligning the second flange with said defined planar surface.

1           198. A polymeric foamed material structure produced in accordance with  
2           the method of Claim 195.

1           199.<sup>49</sup> A method for producing a plurality of polymeric foamed material  
2           structures having slot sections for receiving stud members comprising the steps of:

- 3           a) cutting a polymeric foamed material with a plurality of cutters in a generally  
4           perpendicular direction from a side of the polymeric foamed material;  
5           b) cutting subsequently in at least a second direction the polymeric foamed  
6           material of step (a) with the plurality of cutters until each cutter forms a first  
7           respective slot section in the polymeric foamed material, said first respective

8                   slot section terminating in opposed ends of the polymeric foamed material;  
9                   and  
10                 c) cutting in said generally perpendicular direction of step (a) the polymeric  
11                 foamed material with the plurality of cutters to produce a plurality of  
12                 polymeric foamed material structures having a plurality of first slot sections,  
13                 with each polymeric foamed material structure having one of the first slot  
14                 sections.

B38  
144  
150                 200. <sup>50</sup> The method of Claim <sup>49</sup> wherein said plurality of cutters move  
1                 generally simultaneously.

1                 201. <sup>59</sup> The method of Claim <sup>49</sup> wherein said polymeric foamed material of  
2                 step (a), step (b) and step (c) is generally stationary.

1                 202. <sup>51</sup> The method of Claim <sup>50</sup> wherein said polymeric foamed material of  
2                 step (a), step (b) and step (c) is generally stationary.

1                 203. <sup>60</sup> The method of Claim <sup>49</sup> wherein said at least one second direction  
2                 comprises a second direction generally perpendicular to said generally perpendicular  
3                 direction of step (a).

1                 204. <sup>61</sup> The method of Claim <sup>202</sup> wherein said at least one second direction  
2                 comprises a second direction generally perpendicular to said generally perpendicular  
3                 direction of step (a).

1                 205. <sup>61</sup> The method of Claim <sup>49</sup> additionally comprising cutting with the  
2                 plurality of cutters, before said cutting step (c) and after said cutting step (b), the polymeric  
3                 foamed material in said generally perpendicular direction of step (a) until each cutter forms a  
4                 second respective slot section in the polymeric foamed material, said second respective slot  
5                 section communicating with said first perspective slot section and terminating in opposed  
6                 ends of the polymeric foamed material; and said cutting step (c) subsequently produces a  
7                 plurality of polymeric foamed material structures having a plurality of first slot sections and a  
8                 plurality of second slot sections, with each polymeric foamed material structure having one  
9                 of the first slot sections and one of the second slot sections.

1                 206. <sup>53</sup> The method of Claim <sup>204</sup> additionally comprising cutting with the  
2                 plurality of cutters, before said cutting step (c) and after said cutting step (b), the polymeric  
3                 foamed material in said generally perpendicular direction of step (a) until each cutter forms a

4 second respective slot section in the polymeric foamed material, said second respective slot  
5 section communicating with said first perspective slot section and terminating in opposed  
6 ends of the polymeric foamed material; and said cutting step (c) subsequently produces a  
7 plurality of polymeric foamed material structures having a plurality of first slot sections and a  
8 plurality of second slot sections, with each polymeric foamed material structure having one  
9 of the first slot sections and one of the second slot sections.

1 *B38* 207.4 The method Claim 199 additionally comprising cutting with the  
2 plurality of cutters, before said cutting step (c) and after said cutting step (b), the polymeric  
3 foamed material in said generally perpendicular direction of step (a) and subsequently in a  
4 fourth direction until each cutter forms a second respective slot section and a third respective  
5 slot section in the polymeric foamed material, said second respective slot section  
6 communicating with said first respective slot section and terminating in opposed ends of the  
7 polymeric foamed material and said third respective slot section communicating with said  
8 second respective slot section and terminating in opposed ends of the polymeric foamed  
9 material; and said cutting step (c) subsequently produces a plurality of polymeric foamed  
10 material structures having a plurality of first slot sections, a plurality of second slot sections,  
11 and a plurality of third slot sections, with each polymeric foamed material structure having  
12 one of the first slot sections, one of the second slot sections, and one of the third slot sections.

1 208.53 The method of Claim 204 additionally comprising cutting with the  
2 plurality of cutters, before said cutting step (c) and after said cutting step (b), the polymeric  
3 foamed material in said generally perpendicular direction of step (a) and subsequently in a  
4 fourth direction until each cutter forms a second respective slot section and a third respective  
5 slot section in the polymeric foamed material, said second respective slot section  
6 communicating with said first respective slot section and terminating in opposed ends of the  
7 polymeric foamed material and said third respective slot section communicating with said  
8 second respective slot section and terminating in opposed ends of the polymeric foamed  
9 material; and said cutting step (c) subsequently produces a plurality of polymeric foamed  
10 material structures having a plurality of first slot sections, a plurality of second slot sections,  
11 and a plurality of third slot sections, with each polymeric foamed material structure having  
12 one of the first slot sections, one of the second slot sections, and one of the third slot sections.

1                          67  
209. The method of Claim 199 wherein said plurality of cutters comprise  
hot wire cutters.

1                          69  
210. The method of Claim 199 wherein said plurality of cutters comprise  
laser cutters.

1                          53  
211. The method of Claim 206 additionally comprising computer operating  
said plurality of cutters, and said plurality of cutters are selected from the group consisting of  
hot wire cutters and laser cutters.

1                          55  
212. The method of Claim 208 additionally comprising computer operating  
said plurality of cutters, and said plurality of cutters are selected from the group consisting of  
hot wire cutters and laser cutters.

1                          67  
213. The method of Claim 209 additionally comprising computer operating  
said plurality of hot wire cutters.

1                          69  
214. The method of Claim 210 additionally comprising computer operating  
said plurality of laser cutters.

1                          49  
215. The method of Claim 199 additionally comprising providing a  
plurality of stud members, and disposing the plurality of stud members in said first slot  
sections of said polymeric foamed material structures to produce a plurality of polymeric  
foamed material panels, with each polymeric foamed material panel having one of the stud  
members.

1                          61  
216. The method of Claim 205 additionally comprising providing a  
plurality of stud members, and disposing the plurality of stud members in said first slot  
sections and in said second slot sections of said polymeric foamed material structures to  
provide a plurality of polymeric foamed material panels, with each polymeric foamed  
material panel having one of the stud members.

1                          64  
217. The method of Claim 207 additionally comprising providing a  
plurality of stud members, and disposing the plurality of stud members in said first slot  
sections and in said second slot sections and in said third slot sections of said polymeric  
foamed material structures to produce a plurality of polymeric foamed material panels, with  
each of the polymeric foamed material panels having one of the stud members respectively  
occupying the first slot section, the second slot section and the third slot section associated  
with said each of the polymeric foamed material panels.

1           218. <sup>57</sup> The method of Claim 208 additionally comprising providing a  
2         plurality of stud members, and disposing the plurality of stud members in said first slot  
3         sections and in said second slot sections and in said third slot sections of said polymeric  
4         foamed material structures to produce a plurality of polymeric foamed material panels, with  
5         each of the polymeric foamed material panels having one of the stud members respectively  
6         occupying the first slot section, the second slot section and the third slot section associated  
7         with said each of the polymeric foamed material panels.

1           219. <sup>59</sup> The method of Claim 218 additionally comprising computer operating  
2         said plurality of cutters, and said plurality of cutters are selected from the group consisting of  
3         hot wire cutters and laser cutters.

1           220. <sup>74</sup> A method for producing a plurality of polymeric foamed material  
2         structures having slots for receiving stud members comprising the steps of:

- 3           a) cutting a polymeric foamed material with a plurality of cutters in a generally  
4         perpendicular direction from a side surface of the polymeric foamed material;
- 5           b) cutting subsequently in at least a second direction the polymeric foamed  
6         material of step (a) with the plurality of cutters until each cutter forms a first  
7         respective slot in the polymeric foamed material, said first respective slot  
8         terminating in opposed ends of the polymeric foamed material;
- 9           c) cutting in said generally perpendicular direction of step (a) the polymeric  
10         foamed material with the plurality of cutters to produce a plurality of  
11         polymeric foamed material structures having a plurality of first slots, with  
12         each polymeric foamed material structure having one of the first slots.

1           221. <sup>74</sup> The method of claim 220 additional comprising cutting, prior to said  
2         cutting step (c) and after said cutting step (b), the polymeric foamed material with the  
3         plurality of cutters until each cutter forms a second respective slot in the polymeric foamed  
4         material, said second respective slot terminating in opposed ends of the polymeric foamed  
5         material; and said cutting step (c) subsequently producing a plurality of polymeric foamed  
6         material structures having a plurality of first slots and a plurality of second slots, with each  
7         polymeric foamed material structure having one of the first slots and one of the second slots.

8  
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~~222.~~ The method of Claim 220 additionally comprising computer operating said plurality of cutters, and said plurality of cutters are selected from the group consisting of hot wire cutters and laser cutters.

223<sup>74</sup> The method of Claim 221<sup>75</sup> additionally comprising computer operating said plurality of cutters, and said plurality of cutters are selected from the group consisting of hot wire cutters and laser cutters.

~~not with cutters and base cutter.~~ 224.<sup>77</sup> The method of Claim 223 wherein said polymeric foamed material is generally stationary and said plurality of cutters generally move simultaneously.

**225.<sup>78</sup>** The method of Claim 224 additionally comprising providing a plurality of stud members wherein each of said stud members comprises a web and a flange integrally bound to said web; and disposing the plurality of stud members in said first slots and in said second slots of said polymeric foamed material structures to produce a plurality of polymeric foamed material panels, with each of the polymeric foamed material panels having the web and the flange of one of the stud members respectively occupying the first slot and the second slot associated with said each of the polymeric foamed material panels.

22682 A method for producing a plurality of polymeric foamed material structures having brace-receiving slots comprising the steps of:

- a) providing a generally stationary block of polymeric foamed material having a side surface and a pair of opposed ends;
  - b) moving generally simultaneously from said side surface a plurality of cutters through the block of polymeric foamed material in a generally perpendicular direction of travel, while interrupting at least one time the moving of the plurality of cutters in said generally perpendicular direction of travel to move the cutters through the block of polymeric foamed material in at least one direction of travel comprising a direction which differs from said generally perpendicular direction of travel, such that each cutter produces a respective brace-receiving slot in the polymeric foamed material terminating in said opposed end, until said plurality of cutters have moved completely through the generally stationary block of polymeric foamed material to produce a plurality of polymeric foamed material structures having a plurality of brace-receiving

16 slots, with each polymeric foamed material structure having at least one of the  
17 brace-receiving slots.

1 ~~227~~ The method of Claim ~~226~~ additionally comprising computer operating  
2 said plurality of cutters.

1 ~~228~~ The method of Claim ~~227~~ wherein said plurality of cutters are selected  
2 from the group consisting of hot wire cutters and laser cutters.

1 ~~229~~ The method of Claim ~~226~~ additionally comprising providing a  
2 plurality of brace members; and disposing the plurality of brace members in the plurality of  
3 brace-receiving slots of said polymeric foamed material structures to produce a plurality of  
4 polymeric foamed material panels, with each polymeric foamed material panel having at  
5 least one of the brace members.

1 ~~230~~ The method of Claim ~~228~~ additionally comprising providing a  
2 plurality of brace members; and disposing the plurality of brace members in the plurality of  
3 brace-receiving slots of said polymeric foamed material structures to produce a plurality of  
4 polymeric foamed material panels, with each polymeric foamed material panel having at  
5 least one of the brace members.

1 ~~231~~ The method of Claim ~~226~~ wherein said at least one direction of travel  
2 comprises a first direction of travel, a second direction of travel immediately following said  
3 first direction of travel and being generally parallel to said generally perpendicular direction  
4 of travel, and a third direction of travel immediately following said second direction of travel.

1 ~~232~~ The method of Claim ~~231~~ wherein said first direction of travel is  
2 generally normal to said generally perpendicular direction of travel, and said second direction  
3 of travel is generally normal to said first direction of travel.

1 ~~233~~ The method of Claim ~~228~~ wherein said at least one direction of travel  
2 comprises a first direction of travel, a second direction of travel immediately following said  
3 first direction of travel and being generally parallel to said generally perpendicular direction  
4 of travel, and a third direction of travel immediately following said second direction of travel.

1 ~~234~~ The method of Claim ~~233~~ wherein said first direction of travel is  
2 generally normal to said generally perpendicular direction of travel, and said second direction  
3 of travel is generally normal to said first direction of travel.

1           235. A plurality of polymeric foamed material structures produced in  
2           accordance with the method of Claim 199.<sup>49</sup>

1           236. The plurality of polymeric foamed material structures produced in  
2           accordance with the method of Claim 215.<sup>71</sup>

1           237. A plurality of polymeric foamed material panels produced in  
2           accordance with the method of Claim 216.<sup>62</sup>

1           238. A plurality of polymeric foamed material panels produced in  
2           accordance with the method of Claim 217.<sup>64</sup>

1           239. A plurality of polymeric foamed material structures produced in  
2           accordance with the method of Claim 220.<sup>74</sup>

1           240. A plurality of polymeric foamed material panels produced in  
2           accordance with the method of Claim 225.<sup>78</sup>

1           241. A plurality of polymeric foamed material structures produced in  
2           accordance with the method of Claim 226.<sup>83</sup>

1           242. A plurality of polymeric foamed material panels produced in  
2           accordance with the method of Claim 229.<sup>88</sup>

1           243. A plurality of polymeric foamed material structures produced in  
2           accordance with the method of Claim 231.<sup>90</sup>

#### CONCLUSION

In view of the foregoing, Applicants believe all claims now pending in this Application are in condition for allowance. The issuance of a formal Notice of Allowance at an early date is respectfully requested.